

Work Order ID 83490

April-18-12 2:45:31 PM

83490

Page 1

Item ID: D2665-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Stop

NS2

Start Date: 18/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/19

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2665	Rev D								
100		0.00							
100	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program batch number.1- Inspect part number and batch number are programmed correctly.2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet								
110		0.00							
110	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

F.K 12/07/03

6

F.K 12/07/03

6

F.K 12/07/03

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83490

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Page 2

Item ID: D2665-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

2L 12-07-04

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

6x ϕ 12/07/01

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200 F

9-20

6x ϕ 12/07/05

m121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83490

April-18-12 2:45:31 PM

83490

Page 3

Item ID: D2665-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 18/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

X6 \$ 12/07/05

170

Identify as per dwg & Stock Location: **438**

0.00

170

Packaging

Memo

0.00

Packaging

(6x)

12-7-10 SP

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

CK 12/7/11

MF 12-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-18-12 2:45:34 PM

Page 1

Work Order ID: 83490

83490

Parent Item: D2665-1

D2665-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	71.0000	1	6			

D6101-003

Saddle Billet, 7075

**

Location	Loc Qty	Loc Code
MAT040	26	
73775	2	
73780	7	
78599	10	
80765	0	
MAT041	1	
80765	1	
MAT042	43	
81924	50	
MAT044	1	
73769	1	

85434

6

F.K. 12/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 83490	
Description: 206 Saddle, Outboard, Left side				Part Number: D2665-1	
Inspection Dwg: D2665 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.122	.121	.120	.120	.120
B	0.100	0.140		.105	.106	.106	.106	.106
C	1.125	1.145		1.127	1.135	1.133	1.134	1.135
D	0.615	0.685		.645	.645	.645	.645	.645
E	0.240	0.260		.260	.254	.254	.254	.254
F	1.313	1.343		1.323	1.327	1.328	1.327	1.327
G	0.210	0.230		.216	.224	.225	.225	.225
H	0.100	0.180		.135	.135	.135	.135	.135
I	2.470	2.510		2.492	2.492	2.492	2.492	2.492
J	1.565	1.585		1.567	1.574	1.573	1.574	1.574
K	0.235	0.240		.238	.237	.238	.238	.238
L	0.100	0.120		.113	.112	.113	.113	.113
M	0.990	1.010		1.003	1.003	1.003	1.003	1.003
N	0.510	0.515		.512	.512	.512	.512	.512
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.312	0.318		.314	.314	.314	.314	.314
S	0.315	0.322		.317	.317	.317	.317	.317
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		.797	.795	.795	.797	.797
W	0.540	0.560		.550	.550	.550	.550	.550
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		.258	.258	.258	.258	.258
Z	0.912	0.932		.923	.924	.924	.924	.924
AA	0.490	0.510		.498	.500	.500	.500	.500
AB	0.178	0.198		.188	.188	.188	.188	.188
AC								
AD								
AE								
Accept/Reject								

Measured by: FK	Date: 12/07/03
Audited by: SL	Date: 12-07-04
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	

DART AEROSPACE LTD		Work Order: 83990
Description: 206 Saddle, Outboard, Left side		Part Number: D2665-1
Inspection Dwg: D2665 Rev: D DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

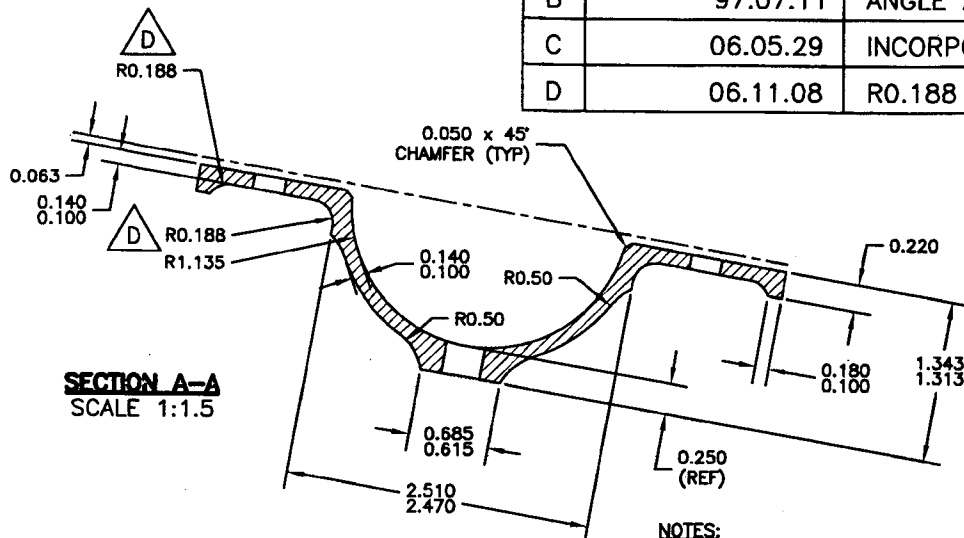
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	2	3	4	5
A	0.100	0.140		.120				
B	0.100	0.140		.106				
C	1.125	1.145		1.135				
D	0.615	0.685		.675				
E	0.240	0.260		.254				
F	1.313	1.343		1.327				
G	0.210	0.230		.225				
H	0.100	0.180		.135				
I	2.470	2.510		2.492				
J	1.565	1.585	1.574	1.569				
K	0.235	0.240		.238				
L	0.100	0.120		.113				
M	0.990	1.010		1.003				
N	0.510	0.515		.512				
O	5.990	6.010		6.000				
P	1.245	1.255		1.250				
Q	2.495	2.505		2.500				
R	0.312	0.318		.314				
S	0.315	0.322		.317				
T	2.495	2.505		2.500				
U	1.357	1.367		1.362				
V	0.787	0.807		.797				
W	0.540	0.560		.550				
X	1.674	1.684		1.679				
Y	0.256	0.262		.258				
Z	0.912	0.932		.924				
AA	0.490	0.510		.497				
AB	0.178	0.198		.188				
AC								
AD								
AE								
Accept/Reject								

Measured by: Fk.	Date: 12/07/04
Audited by: SL	Date: 12-07-04
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B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	



DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>CB</i>	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD OUTSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

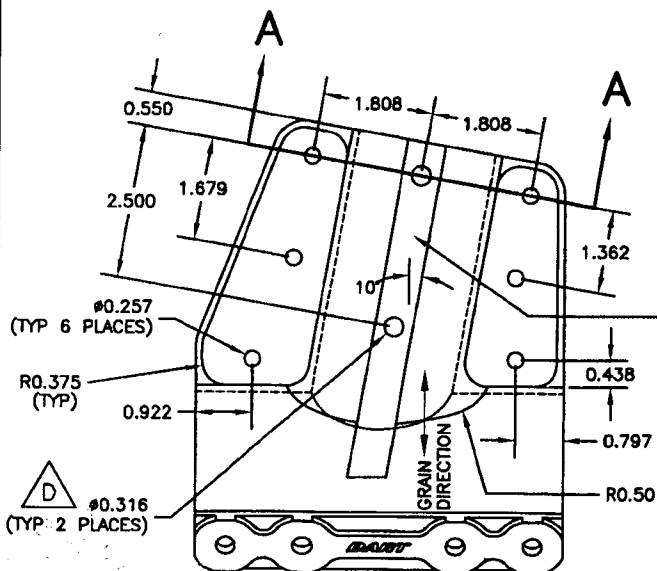


RELEASED
07.02.12

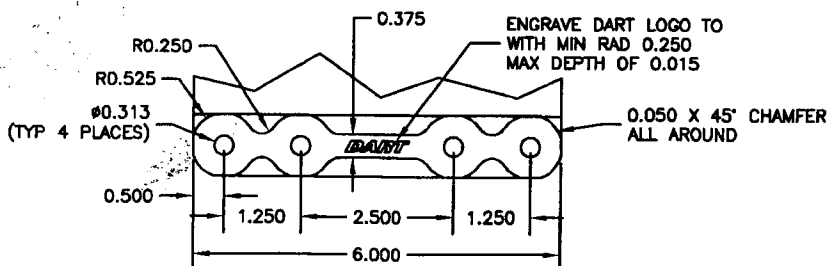
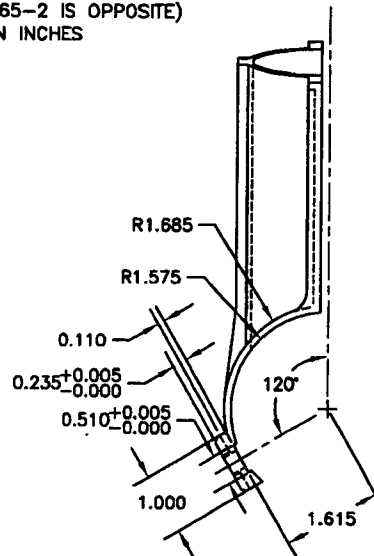
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83490 MLC
12/01/19

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



D2665-1 SADDLE FWD OUTSIDE HIGH

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